

## IN THE CLAIMS

1. (previously presented) A multilayer washable material which comprises:
  - a moisture-permeable top layer material (2), a moisture-impermeable bottom layer material (3), and at least one layer of a textile material used as a moisture-absorption element (1) positioned between the top layer and the bottom layer;
    - the layers being joined to one another by means of an adhesive composition, wherein an interfacial region between each pair of layers bearing against one another exists;
    - wherein in the interfacial region between each pair of layers bearing against one another there is an adhesive composition in the form of a pattern which is sufficiently dense to prevent wrinkling, and which is sufficiently open to prevent the material from becoming inflexible;
    - wherein the pattern in which the adhesive composition is present is selected from:
      - a) a dot lining pattern,
      - b) separately positioned pattern parts which are separated by regions where there is no adhesive composition,
      - c) a number of pattern parts (4, 22) which are identical in shape and one or more pattern parts (21) of a different shape,
      - d) the patterns described under b) and/or c), with one or more pattern parts being formed from a dot lining pattern,
      - e) a dot lining pattern as described under a) in which there are parts without any dots,
    - and combinations of the patterns described under a) to e);
  - wherein the moisture-permeable top layer is made of a fraying-free fabric;
  - wherein no finishing of the multilayer material, as such and/or of a smaller part obtained therefrom, is carried out; and
  - wherein a quantity of applied adhesive composition is from 6 to 40 g/m<sup>2</sup>.
  2. (canceled)
  3. (canceled)

4. (previously presented) The multilayer assembly according to claim 1, wherein a pattern part of a different shape is a border (21), the external dimensions of which correspond to the dimensions of the use product, which it is desired to form from the multilayer material by dividing up the latter.

5. (previously presented) The multilayer material according to claim 1, wherein the adhesive composition is selected from solidified, nonreactive thermoplastic material and a fully moisture-cured reactive hotmelt adhesive.

6. (previously presented) The multilayer material according to claim 5, wherein the adhesive composition is a fully moisture-cured reactive polyurethane hotmelt adhesive.

7. (previously presented) The multilayer material according to claim 1, wherein it comprises one or more additional layers of material selected from an anti-allergy layer, a resilient foam layer, a dispersion layer, an anti-bedsore layer and an anti-odour layer, which are bonded to the moisture-absorption element (1) and the top layer material (2) or the bottom layer material (3).

8. (previously presented) A method for producing a multilayer washable material which comprises a moisture-permeable top layer material (2), a moisture-permeable bottom layer material (3) and at least one layer of a textile material used as a moisture-absorption element (1) positioned between them, wherein a top layer material (2), a bottom layer material (3) and an interlayer material (1) are provided and are joined to one another using an adhesive composition, wherein an interfacial region between each pair of layers bearing against one another is formed, wherein an adhesive composition is applied in a quantity of from 6 to 40 g/m<sup>2</sup> in the form of a pattern which prevents wrinkling and which is sufficiently open to prevent the material from becoming inflexible both in the interfacial region which is to be formed between top layer material (2) and interlayer material (1) and in the interfacial region which is to be formed between bottom layer material (3) and interlayer material (1), and the layers are brought to bear against one another and are joined to one another as the adhesive composition sets, wherein the moisture-permeable top layer is made of a fraying-free fabric, with no finishing of the multilayer material as such and/or a smaller part which is cut from it, being carried out.

9. (previously presented) The method according to claim 8, wherein the adhesive composition is selected from a nonreactive thermoplastic material which is solid under ambient

conditions and a moisture-curable plastic material, and it is applied in the form of a melt at a temperature which is higher than the melting point of the plastic material used.

10. (previously presented) The method according to claim 9, wherein a moisture-curable plastic material is applied to the top layer material (2) and the bottom layer material (3).

11. (previously presented) The method according to claim 10, wherein a molten moisture-curable plastic material is applied with the aid of screen printing, with at least the stencil used being heated to above the melting point of the moisture-curable plastic material used.

12. (previously presented) The method according to claim 11, wherein the screen printing used is rotary screen printing using one or more seamless cylindrical metal stencils (5, 6).

13. (previously presented) The method according to claim 9, wherein the moisture-curable plastic material used is a plastic material selected from a reactive polyurethane hotmelt adhesive and a reactive polyalkene hotmelt adhesive.

14. (previously presented) The method according to claim 13, wherein a reactive polyurethane hotmelt adhesive is used.

15. (previously presented) The method according to claim 8, wherein to form a multilayer material in the form of a washable underpad with the aid of rotary screen printing, a pattern of a moisture-curable plastic material is applied to a moisture-permeable top layer material (2) and to a moisture-impermeable bottom layer material (3), and the materials which have been coated in this way are combined with a moisture-absorption element (1) in such a manner that the sides of the top layer material (2) and the bottom layer material (3) which comprise moisture-curable plastic material bear against the two surfaces of the moisture-absorption element (1), and curing of the moisture-curable plastic material bonds together the top layer material (2), bottom layer material (3) and the moisture-absorption element.

16. (previously presented) The method according to Claim 15, wherein the top layer material (2) and the bottom layer material (3) are in web form, and moisture-curable plastic material (7, 9) is applied to both materials simultaneously with the aid of two rotary screen-printing stencils (5, 6), and the top layer and bottom layer materials which have been coated in

this way are brought to bear against a moisture-absorption element in web form, after which moisture-curing of the moisture-curable plastic material bonds together the top layer material (2), bottom layer material (3), and moisture-absorption element (1).

17. (previously presented) The method according to Claim 16, wherein it is carried out continuously, and after an assembly of top layer material (2), bottom layer material (3) and moisture-absorption element (1) in web form has been formed, the web is divided into separate, washable underpads by cutting, and these underpads are used without finishing.

18. (previously presented) The method according to claim 8, wherein to fully cure the moisture-curable plastic, moisture is supplied in an amount sufficient to enable the moisture-curable plastic on the top layer material (2) and bottom layer material (3) to cure fully.

19. (previously presented) The method according to claim 8, wherein the pattern in which the adhesive composition is applied is selected from:

- a) a dot lining pattern,
- b) separately positioned pattern parts which are separated by regions where there is no adhesive composition,
- c) a number of pattern parts (4, 22) which are identical in shape and one or more pattern parts (21) of a different shape,
- d) the patterns described under b) and/or c), with one or more pattern parts being formed from a dot lining pattern,
- e) a dot lining pattern as described under a) in which there are parts without any dots,

and combinations of the patterns described under a) to e).

20. (previously presented) The method according to claim 19, wherein the pattern on the top layer material (2) and the bottom layer material (3) extends over the entire surface thereof and comprises dots, or the pattern parts (4, 21, 22) are composed of dots.

21. (previously presented) The method according to claim 15, wherein one or more additional layers of material selected from an anti-allergy layer, a resilient foam layer, a dispersion layer, a bedsore-inhibiting layer and an anti-odour layer are applied and these layers

are bonded to the absorption element (1) and the top layer material (2) or the bottom layer material (3).